

Work Order ID 72038

Monday, July 18, 2011 11:17:10 AM

Page 1

Item ID: D212-664-101TRN

Revision ID: ~~U/R~~ *JS*

Item Name: Crosstube Turning Detail

Start Date: 7/18/2011 Start Qty: 1.00

Required Date: 7/22/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-664-141

~~Rev D U/R~~ *WBS* *11/07/26*

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs D18534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

mm, L

11/07/19

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

JK 11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72038

Monday, July 18, 2011 11:17:10 AM

Page 2

Item ID: D212-664-101TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail

Accept

Setup Start

Stop

Start Date: 7/18/2011 Start Qty: 1.00

Required Date: 7/22/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

1-Turn second side as per Folio FA113

2-Blend transition lines only. **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

3-Remove sand and plugs

0.00

0.00

0.00

0.00

0.00

0.00

130



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

M.M.L 11/07/20

JK 11-07-25

Jul 11-07-25 11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 72038

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Item ID: D212-664-101TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail

Accept



Setup Start



Stop



Start Date: 7/18/2011 Start Qty: 1.00

Required Date: 7/22/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Crosstubes Chemical Conversion

0.00

SAD
Ac 11-07-25

1 0

HandFXtube

Memo

0.00

Hand Finishing-Crosstubes

160

QC3- Inspect Part Finish

0.00

DD

11-7-25

QC

Memo

0.00

Quality Control

170

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rack
Location: WA

SAD

11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 72038

Monday, July 18, 2011 11:17:10 AM



Page 4

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/2/26
11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 11:17:07 AM

Page 1

Work Order ID: 72038

Parent Item: D212-664-101TRN

Parent Item Name: Crosstube Turning Detail



Start Date: 7/18/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6005-128

Manufactured No

120

Each

0.0000

1

1



Crosstube Material

D6005-180

D59307

1 mm. L 11/07/20

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42038
Description: Crosstube Assembly (205/212/412 High Fwd)		Part Number: D212-664-141
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	2.00	✓		vern	JF-01
	R0.063	+/-0.010	0.063	✓		R.G	
	2.740	+0.005/-0.000	2.743	✓		vern	JF-01
	5.097	+/-0.030	5.095	✓		"	
	2.304	+0.005/-0.000	2.309	✓		mic	CNC-04
	2.340	+0.005/-0.000	2.345	✓		"	
	2.398	+0.005/-0.000	2.403	✓		"	
	2.448	+0.005/-0.000	2.453	✓		"	
	2.498	+0.005/-0.000	2.503	✓		"	
	2.549	+0.005/-0.000	2.554	✓		"	
	2.599	+0.005/-0.000	2.604	✓		"	
	2.671	+0.005/-0.000	2.676	✓		"	
	2.701	+0.005/-0.000	2.706	✓		"	
SIDE B	0.200	+/-0.010	2.00	✓		vern	JF-01
	R0.063	+/-0.010	0.063	✓		R.G	
	2.740	+0.005/-0.000	2.741	✓		vern	JF-01
	5.097	+/-0.030	5.095	✓		"	
	2.304	+0.005/-0.000	2.309	✓		mic	CNC-04
	2.340	+0.005/-0.000	2.345	✓		"	
	2.398	+0.005/-0.000	2.403	✓		"	
	2.448	+0.005/-0.000	2.453	✓		"	
	2.498	+0.005/-0.000	2.503	✓		"	
	2.549	+0.005/-0.000	2.554	✓		"	
	2.599	+0.005/-0.000	2.604	✓		"	
	2.671	+0.005/-0.000	2.676	✓		"	
	2.701	+0.005/-0.000	2.706	✓		"	
	126.514	+/-0.020	126.520	✓		tape	MM.L-02

Measured by: MAM. L/S	Audited by: J. J. J.	Prototype Approval:	N/A
Date: 11/02/19	Date: 11-04-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	
D	10.02.02	Dimension 126.514 was 126.51	KJ	

000
00
00

8 7 6 5 4 3 2 1

D

Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS
6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BEEN TIGHTENED OUT AFTER TORQUING.

AB 11/07/29

UNDER REVIEW

11.16.17
FOR PRE-SEPLING SHEET

DEO ATTACHED

RELEASED

2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C8-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

12 13 15
D2893-1 SUPPORT
MS21920-25 CLAMP, 2X
D3595-063-450 RUBBER CUSHION, 2X
2 PL

A4-2

A

A

14.00 (-141)
OR 13.75 (-141B)



D212-664-501
BENT TUBE

CL
SYM

D212-664-141/-141B
ASSEMBLY DETAIL



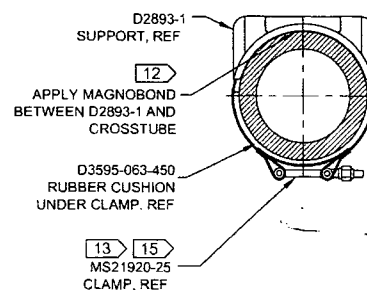
11/07/29

UNDER REVIEW

11.06.13

DEO ATTACHED

RELEASED
2009-10-29



SECTION A-A
SCALE 4X DS-2

72038

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 2 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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8 7 6 5 4 3 2 1

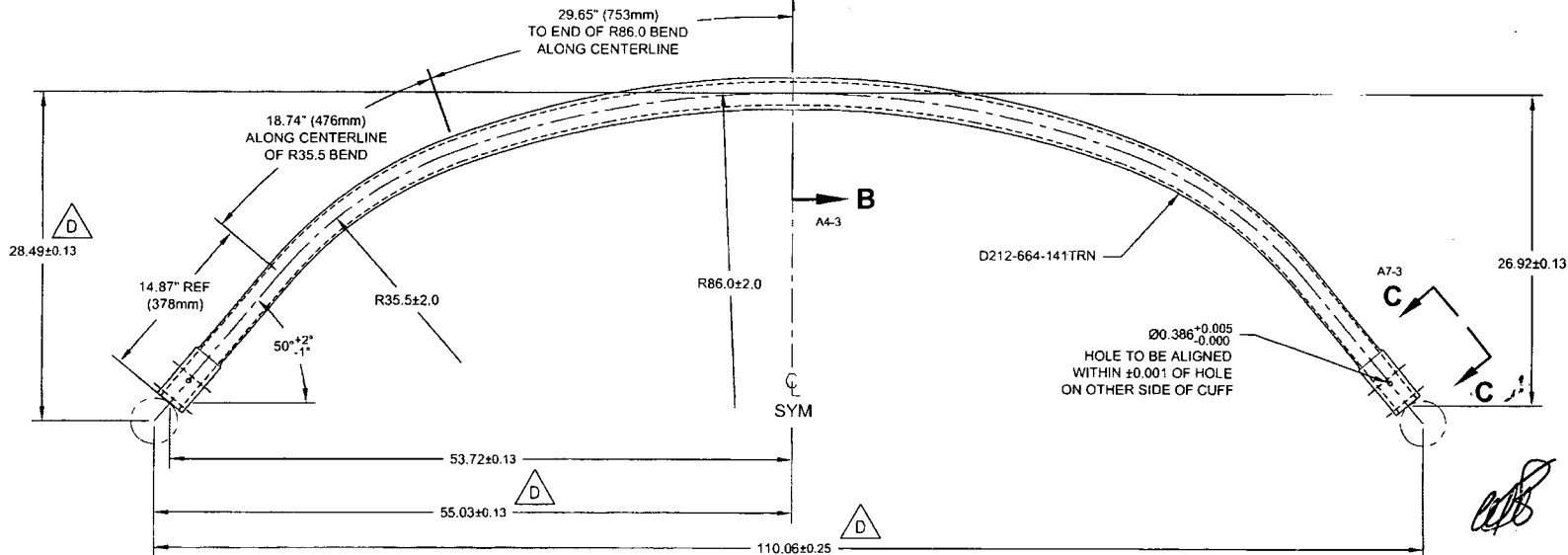
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



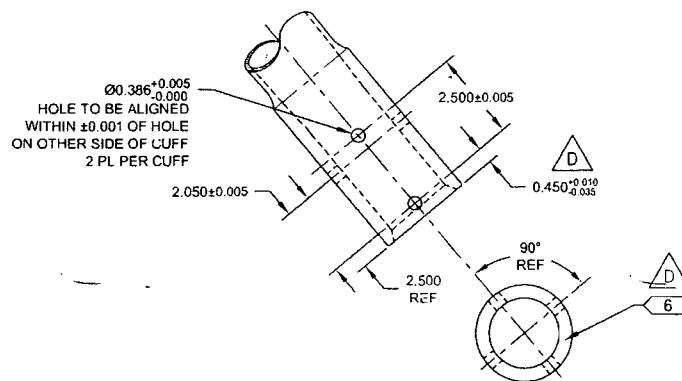
D212-664-501
BENDING AND DRILLING DETAIL

10 D

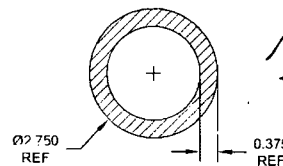
11/07/29
UNDER REVIEW
11/06/13

DEO ATTACHED

RELEASED
2009-10-29
MD



VIEW C-C: CUFF DETAIL C2-3
SCALE 3X



SECTION B-B C4-3
SCALE 4X

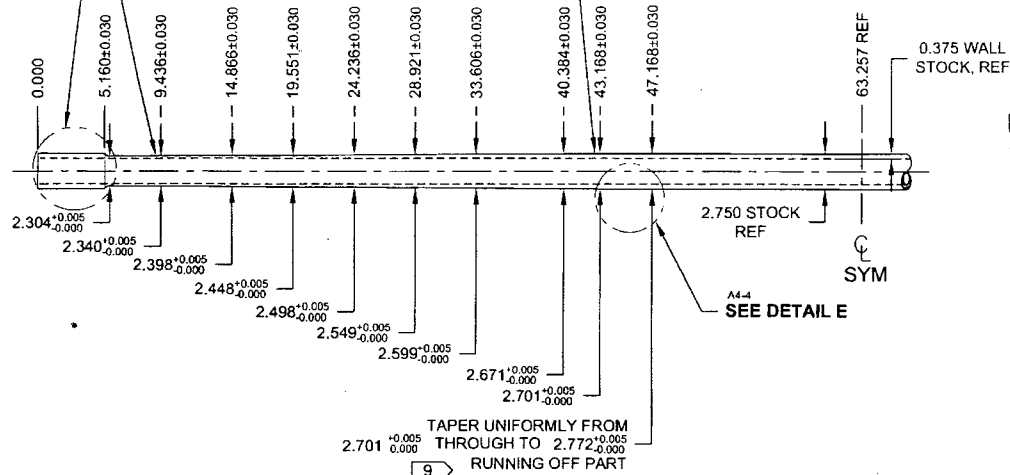
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	AS	D212-664-141	SHEET 3 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	PH	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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8 7 6 5 4 3 2 1

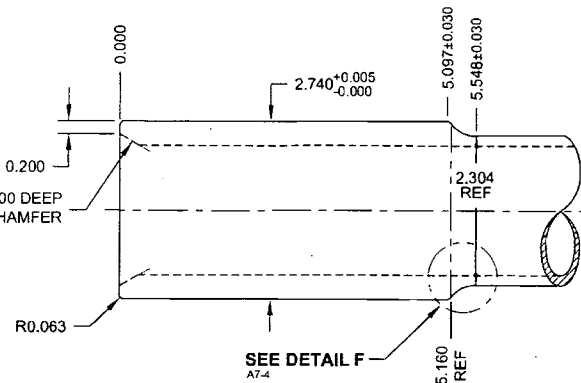
C2-4
SEE DETAIL D

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS



A4-4
SEE DETAIL E



DETAIL D:
CROSSTUBE CUFF DB-4
SCALE 5X

11/07/29

UNDER REVIEW

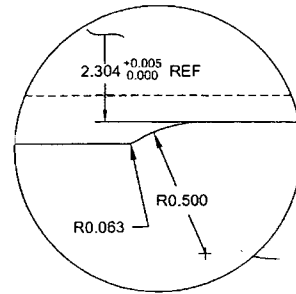
11.06.13

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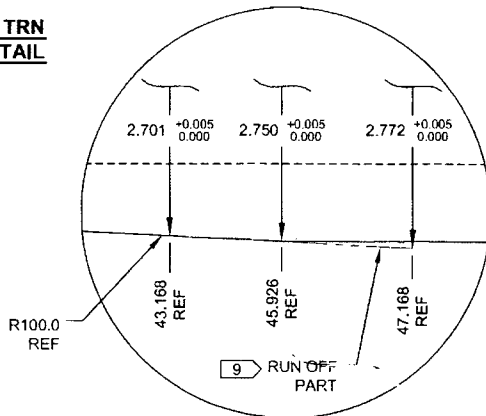
RELEASED
2009 -10- 2 9

and

D212-664-141TRN
TURNING DETAIL



DETAIL F:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL E:
TAPER RUN-OFF C5-4
NOT TO SCALE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	18	D212-664-141	SHEET 4 OF 4
APPROVED	18	TITLE	SCALE
DE APPR.	18	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>EE</i>	APPROVED <i>MA</i>		DE APPR. <i>H</i>		
DATE 11.04.07	DATE 11.07.11	DATE 11.04.12	DATE 11/04/12		DATE 11.04.12		

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED
2011-04-18

MB 11/07/29
UNDER REVIEW

UP 11.06.13

ross

DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

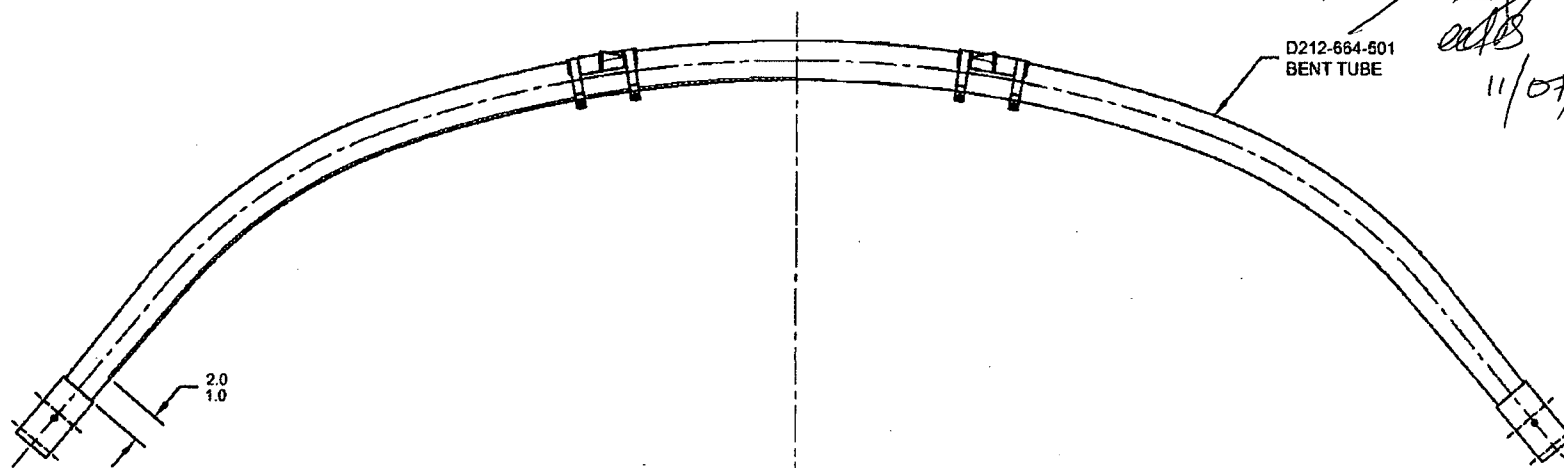
WAS:

UNDER REVIEW

11.06.13

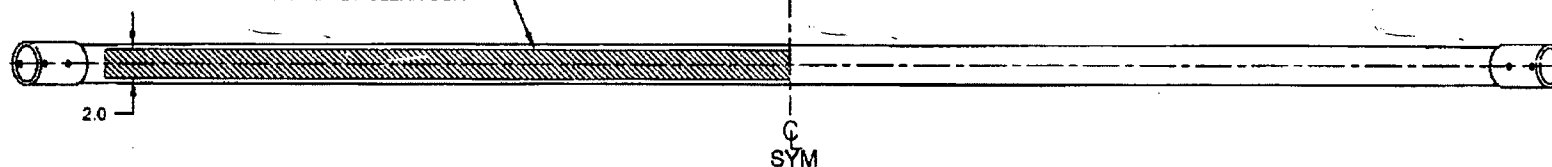
D212-664-601
BENT TUBE

11/07/29



**D212-664-141/-141B
ASSEMBLY DETAIL**

MASK AREA PRIOR TO PAINTING,
REMOVE MASKING AFTER PAINT
AND APPLY CLEAR COAT



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